

Work Order ID 108753

October-29-13 9:56:04 AM

\*108753\*

Page 1

Item ID: D2344

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Deck Plate Aft

Start Date: 10/29/13 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 13-10-31

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |  |  |  |  |  |  |  |  |
|----------|--------------|--|--|--|--|--|--|--|--|
|----------|--------------|--|--|--|--|--|--|--|--|

|       |       |  |  |  |  |  |  |  |  |
|-------|-------|--|--|--|--|--|--|--|--|
| D2344 | Rev F |  |  |  |  |  |  |  |  |
|-------|-------|--|--|--|--|--|--|--|--|

100 0.00

\*100\* FLOW WATER JET

Waterjet Memo 0.00

FLOW CNC Waterjet 1-Cut as per dwg  
prog rev: F  
dwg rev: F

2-deburr as required

110 0.00

\*110\* QC2- Inspect parts off machine FAI/FAIB

QC Memo 0.00

Quality Control

14 0 Jm13-11-15

14 0 Jm13-11-15

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| Work Order: _____   |      |      | DISPOSITION                                |   |                                    | AGAINST DEPARTMENT/PROCESS                   |                                      |   |             |              |              |  |  |   |  |
|---|------|------|--|---|------------------------------------|--|--------------------------------------|---|-------------|--------------|--------------|--|--|---|--|
|   |      |      | Rework <input type="checkbox"/>            | Skid-tube <input type="checkbox"/>  | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/>           | Engineering <input type="checkbox"/> |   |             |              |              |  |  |   |  |
|   |      |      | Scrap <input type="checkbox"/>             | Machining <input type="checkbox"/>  | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/>    | Quality <input type="checkbox"/>     |   |             |              |              |  |  |   |  |
|   |      |      | Use-as-is <input type="checkbox"/>         | Thermoforming <input type="checkbox"/>  | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>       |   |             |              |              |  |  |   |  |
|   |      |      | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/>  | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/>            |                                      |   |             |              |              |  |  |   |  |
| Root Cause  | Date | Step | Qty  | Description of work order update or Non-conformance   |                                    | Initial Chief Eng                            | Action Description                   |   | Sign & Date | Verification | QC Inspector |  |  |   |  |
| Doc/Data  |      |      |  |   |                                    |  |                                      |   |             |              |              |  |  |   |  |
| Equip/Tooling   |      |      |  |   |                                    |  |                                      |   |             |              |              |  |  |   |  |
| Operator  |      |      |  |   |                                    |  |                                      |   |             |              |              |  |  |   |  |
| Material  |      |      |  |   |                                    |  |                                      |   |             |              |              |  |  |   |  |
| Setup   |      |      |  |   |                                    |  |                                      |   |             |              |              |  |  |   |  |
| Other   |      |      |  |   |                                    |  |                                      |   |             |              |              |  |  |   |  |
| Process   |      |      |  |   |                                    |  |                                      |   |             |              |              |  |  |   |  |
| Supplier  |      |      |  |   |                                    |  |                                      |   |             |              |              |  |  |   |  |
| Training  |      |      |  |   |                                    |  |                                      |   |             |              |              |  |  |   |  |
| Unapproved  |      |      |  |   |                                    |  |                                      |   |             |              |              |  |  |   |  |
| FAULT CATEGORY  |      |      |  |   |                                    |  |                                      |   |             |              |              |  |  |   |  |
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube |      |      |  | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio |                                    |  |                                      | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions |             |              |              | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge |  | <input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled |  |
|   |      |      |  |   |                                    |  |                                      |   |             |              |              |  |  | <input type="checkbox"/> Other  |  |
|   |      |      |  |   |                                    |  |                                      |   |             |              |              |  |  |   |  |
|   |      |      |  |   |                                    |  |                                      |   |             |              |              |  |  |   |  |

Work Order ID 108753

\*108753\*

Page 2

October-29-13 9:56:04 AM

Item ID: D2344

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Deck Plate Aft

Start Date: 10/29/13 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

| Sequence ID/<br>Work Center ID               | Operation<br>Description                               | Set Up/<br>Run Hours      | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--|--|---------------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120<br><b>*120*</b><br>QC<br>Quality Control | QC8- Inspect parts - second check                      | 0.00<br>DAS<br>27<br>9-89 | 14      |        |              |               |               |                  |                |
| 130<br><b>*130*</b><br>Small Fab             | Memo   | 0.00<br>13/11/13          | 14X     |        |              |               |               |                  |                |
| 130<br><b>*130*</b><br>Small Fab             | Small Fab  | 0.00                      |         |        |              |               |               |                  |                |
|  | Memo   | 0.00                      |         |        |              |               |               |                  |                |
|  | 1-Deburr sharp edges 2-Countersink holes per Dwg D2344 |                           |         |        |              |               |               |                  |                |
| 140<br><b>*140*</b><br>QC<br>Quality Control | QC5- Inspect part completeness to step on W/O          | 0.00<br>DAS<br>27<br>9-89 | 14      |        |              |               |               |                  |                |
|  | Memo   | 0.00<br>13/11/19          |         |        |              |               |               |                  |                |

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|                   |  |                                    |  |  |                                    |   |                                      |  |
|-------------------|--|------------------------------------|--|--|------------------------------------|---|--------------------------------------|--|
| Work Order: _____ | DISPOSITION                                |                                    |  | AGAINST DEPARTMENT/PROCESS                   |                                    |   |                                      |  |
| Part No. _____    | Rework <input type="checkbox"/>            | Scrap <input type="checkbox"/>     | Use-as-is <input type="checkbox"/>     | Skid-tube <input type="checkbox"/>           | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/>        | Engineering <input type="checkbox"/> |  |
| NCR No. _____     | Work Order Update <input type="checkbox"/> | Machining <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Small Fab <input type="checkbox"/>           | Finishing <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/>     |  |
|                   |  | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/>     | Rec/Store/Packaging <input type="checkbox"/> | Supplier <input type="checkbox"/>  | Other <input type="checkbox"/>            | Other <input type="checkbox"/>       |  |

| Root Cause    | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Setup         |      |      |     |   |                   |                    |             |              |              |
| Other         |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Unapproved    |      |      |     |   |                   |                    |             |              |              |

| FAULT CATEGORY                                     |  |  |   |  |   |   |  |  |  |
|--|--|--|---|--|---|---|--|--|--|
| Landing Gear                                       |  |  | General                                 |  |   |   |  |  |  |
|  |  |  | Bending <input type="checkbox"/>        | Bend <input type="checkbox"/>                            | Grain <input type="checkbox"/>                | Ovalized <input type="checkbox"/>           | Pressure/Forced <input type="checkbox"/> |  |  |
| Centre Not Concentric to O/S                       |  |  | BOM/Route <input type="checkbox"/>      | Hardware <input type="checkbox"/>                        | Over/Under tolerance <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/>   |  |  |  |
| Cracks <input type="checkbox"/>                    |  |  | Broken/Damaged <input type="checkbox"/> | Inspection Incomplete <input type="checkbox"/>           | Part Incorrect <input type="checkbox"/>       | Weld <input type="checkbox"/>               |  |  |  |
| Crushed/Crimped <input type="checkbox"/>           |  |  | Burrs <input type="checkbox"/>          | Instructions Incomplete/Unclear <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/>    | Wrong Stock Pulled <input type="checkbox"/> |  |  |  |
| Cuffs <input type="checkbox"/>                     |  |  | Contamination <input type="checkbox"/>  | Maintenance <input type="checkbox"/>                     | Part Moved <input type="checkbox"/>           |   |  |  |  |
| Heat Treat <input type="checkbox"/>                |  |  | Countersink <input type="checkbox"/>    | Mislabeled <input type="checkbox"/>                      | Positioned Wrong <input type="checkbox"/>     |   |  |  |  |
| Inspection Strip in Tube <input type="checkbox"/>  |  |  | Cut Too Short <input type="checkbox"/>  | Misread <input type="checkbox"/>                         | Power Loss/Surge <input type="checkbox"/>     |   |  |  |  |
| Ripples in Bend <input type="checkbox"/>           |  |  | Drill Holes <input type="checkbox"/>    | Offset <input type="checkbox"/>                          | Other <input type="checkbox"/>                |   |  |  |  |
| Torque Waves in Extrusion <input type="checkbox"/> |  |  | Drawing <input type="checkbox"/>        | Out of Calibration <input type="checkbox"/>              |   |   |  |  |  |
| Turning Sequence <input type="checkbox"/>          |  |  | Finish <input type="checkbox"/>         | Out of Sequence <input type="checkbox"/>                 |   |   |  |  |  |
| Wave/Twist in Tube <input type="checkbox"/>        |  |  | Folio <input type="checkbox"/>          | Outside Dimensions <input type="checkbox"/>              |   |   |  |  |  |

Work Order ID 108753

October-29-13 9:56:04 AM

\*108753\*

Page 3

Item ID: D2344

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Deck Plate Aft

Start Date: 10/29/13 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals:

Process Plan:

Date: Tooling:

Date:

Run Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

| Sequence ID/<br>Work Center ID                          | Operation<br>Description   | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp   |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|--|
| 150<br><br><b>*150*</b><br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br><br>Memo  | 0.00<br>0.00         |         |        |              |               |               |                  | <u>14</u> <u>10/13/13</u>  |
| 155<br><br><b>*155*</b><br>QC<br>Quality Control        | QC7-Inspect Chemical Conversion Coat<br><br>Memo   | 0.00<br>0.00         |         |        |              |               |               |                  | <u>14</u> <u>10/13/13</u> <u>DAS</u><br><u>34</u><br><u>9-89</u> |
| 160<br><br><b>*160*</b><br>Powdercoat<br>Powder Coating | Black Sandtex(Ref 4.3.5.7) per QSI005 4.3<br><br><i>M117338</i><br>Memo<br>START TIME: <u>10:30</u> FINISH TIME: <u>11:00</u> OVEN TEMPERATURE: <u>100</u> | 0.00<br>0.00         |         |        |              |               |               |                  | <u>14</u> <u>10/13/13</u> <u>DAS</u><br><u>34</u><br><u>9-89</u> |

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order ID 108753

October-29-13 9:56:04 AM

\*108753\*

Page 4

Item ID: D2344

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Deck Plate Aft

Stop

\*NS2\*

Start Date: 10/29/13 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

\*170\*

QC

Quality Control

QC3- Inspect Part Finish

0.00

14X

13-11-21

DAS  
26  
9-89

180

\*180\*

Packaging

Packaging

Identify as per dwg & Stock Location: ST220A

0.00

14X

DAS  
26  
9-89

B-11-21

190

\*190\*

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

13/11/22 JJ

11/13-11-21

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| Work Order: _____ |                          |                              | DISPOSITION                                |   |                                    | AGAINST DEPARTMENT/PROCESS                   |                                      |                    |             |              |              |
|-------------------|--------------------------|------------------------------|--|---|------------------------------------|--|--------------------------------------|--------------------|-------------|--------------|--------------|
| Part No. _____    |                          |                              | Rework <input type="checkbox"/>            | Skid-tube <input type="checkbox"/>                  | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/>           | Engineering <input type="checkbox"/> |                    |             |              |              |
| NCR No. _____     |                          |                              | Scrap <input type="checkbox"/>             | Machining <input type="checkbox"/>                  | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/>    | Quality <input type="checkbox"/>     |                    |             |              |              |
|                   |                          |                              | Use-as-is <input type="checkbox"/>         | Thermoforming <input type="checkbox"/>              | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>       |                    |             |              |              |
|                   |                          |                              | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/>                  | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/>            |                                      |                    |             |              |              |
| Root Cause        | Date                     | Step                         | Qty  | Description of work order update or Non-conformance |                                    | Initial Chief Eng                            | Action Description                   |                    | Sign & Date | Verification | QC Inspector |
| Doc/Data          |                          |                              |  |   |                                    |  |                                      |                    |             |              |              |
| Equip/Tooling     |                          |                              |  |   |                                    |  |                                      |                    |             |              |              |
| Operator          |                          |                              |  |   |                                    |  |                                      |                    |             |              |              |
| Material          |                          |                              |  |   |                                    |  |                                      |                    |             |              |              |
| Setup             |                          |                              |  |   |                                    |  |                                      |                    |             |              |              |
| Other             |                          |                              |  |   |                                    |  |                                      |                    |             |              |              |
| Process           |                          |                              |  |   |                                    |  |                                      |                    |             |              |              |
| Supplier          |                          |                              |  |   |                                    |  |                                      |                    |             |              |              |
| Training          |                          |                              |  |   |                                    |  |                                      |                    |             |              |              |
| Unapproved        |                          |                              |  |   |                                    |  |                                      |                    |             |              |              |
| FAULT CATEGORY    |                          |                              |  |   |                                    |  |                                      |                    |             |              |              |
| Landing Gear      | General                  |                              |  |   |                                    |  |                                      |                    |             |              |              |
|                   | <input type="checkbox"/> | Bending                      | <input type="checkbox"/>                   | Grain   | <input type="checkbox"/>           | Ovalized                                     | <input type="checkbox"/>             | Pressure/Forced    |             |              |              |
|                   | <input type="checkbox"/> | Centre Not Concentric to O/S | <input type="checkbox"/>                   | BOM/Route   | <input type="checkbox"/>           | Over/Under tolerance                         | <input type="checkbox"/>             | Temperature/Cure   |             |              |              |
|                   | <input type="checkbox"/> | Cracks                       | <input type="checkbox"/>                   | Broken/Damaged                                      | <input type="checkbox"/>           | Part Incorrect                               | <input type="checkbox"/>             | Weld               |             |              |              |
|                   | <input type="checkbox"/> | Crushed/Crimped              | <input type="checkbox"/>                   | Burrs   | <input type="checkbox"/>           | Part Lost/Missing                            | <input type="checkbox"/>             | Wrong Stock Pulled |             |              |              |
|                   | <input type="checkbox"/> | Cuffs                        | <input type="checkbox"/>                   | Contamination                                       | <input type="checkbox"/>           | Part Moved                                   | <input type="checkbox"/>             |                    |             |              |              |
|                   | <input type="checkbox"/> | Heat Treat                   | <input type="checkbox"/>                   | Countersink   | <input type="checkbox"/>           | Positioned Wrong                             | <input type="checkbox"/>             |                    |             |              |              |
|                   | <input type="checkbox"/> | Inspection Strip in Tube     | <input type="checkbox"/>                   | Cut Too Short                                       | <input type="checkbox"/>           | Power Loss/Surge                             | <input type="checkbox"/>             |                    |             |              |              |
|                   | <input type="checkbox"/> | Ripples in Bend              | <input type="checkbox"/>                   | Drill Holes   | <input type="checkbox"/>           | <input type="checkbox"/>                     |                                      |                    |             |              |              |
|                   | <input type="checkbox"/> | Torque Waves in Extrusion    | <input type="checkbox"/>                   | Drawing   | <input type="checkbox"/>           | <input type="checkbox"/>                     |                                      |                    |             |              |              |
|                   | <input type="checkbox"/> | Turning Sequence             | <input type="checkbox"/>                   | Finish  | <input type="checkbox"/>           | <input type="checkbox"/>                     |                                      |                    |             |              |              |
|                   | <input type="checkbox"/> | Wave/Twist in Tube           | <input type="checkbox"/>                   | Folio   | <input type="checkbox"/>           | <input type="checkbox"/>                     |                                      |                    |             |              |              |
|                   |                          |                              |  |   |                                    |  |                                      |                    |             |              |              |
|                   |                          |                              |  |   |                                    |  |                                      |                    |             |              |              |
|                   |                          |                              |  |   |                                    |  |                                      |                    |             |              |              |

# Picklist Print

October-29-13 9:56:03 AM

Page 1

Work Order ID: 108753

Parent Item: D2344

Parent Item Name: Deck Plate Aft

Start Date: 10/29/13

Required Date: 10/29/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:D00.06.26Removed P/O for powder coatEC

IPP Rev:E 07-07-04 Asper Rev F JLM

| Component Item ID/<br>Item Name    | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M2024T3S.063<br>2024-T3 .063 sheet |                        | Purchased     | No          |                     |                  | 100             | sf                 | 299.5789       | 0.745       | 6.273684     | 12            | JM13-11-15     |        |

| Location | Loc Qty  | Loc Code |
|----------|----------|----------|
| MAT022   | 299.5789 |          |
| 119916   | 0.2      |          |
| 121197   | 21.34    |          |
| 123096   | 11.4     |          |
| 123654   | 11.64    |          |
| 123701   | 16.1039  |          |
| 125341   | 87.94    |          |
| 125636   | 150.955  | 125636   |

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| Work Order: _____   |      |      | DISPOSITION                     |  |  | AGAINST DEPARTMENT/PROCESS             |                                    |  |                                      |              |  |
|---|------|------|---------------------------------|--|--|--|------------------------------------|--|--------------------------------------|--------------|--|
|   |      |      | Rework <input type="checkbox"/> | Scrap <input type="checkbox"/>   | Use-as-is <input type="checkbox"/>         | Skid-tube <input type="checkbox"/>     | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/>           | Engineering <input type="checkbox"/> |              |  |
|   |      |      |                                 |  | Work Order Update <input type="checkbox"/> | Machining <input type="checkbox"/>     | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/>    | Quality <input type="checkbox"/>     |              |  |
|   |      |      |                                 |  |  | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>       |              |  |
|   |      |      |                                 |  |  | Large Fab <input type="checkbox"/>     | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/>            |                                      |              |  |
| Root Cause  | Date | Step | Qty                             | Description of work order update or Non-conformance  |  | Initial Chief Eng                      | Action Description                 | Sign & Date                                  | Verification                         | QC Inspector |  |
| Doc/Data  |      |      |                                 |  |  |  |                                    |  |                                      |              |  |
| Equip/Tooling   |      |      |                                 |  |  |  |                                    |  |                                      |              |  |
| Operator  |      |      |                                 |  |  |  |                                    |  |                                      |              |  |
| Material  |      |      |                                 |  |  |  |                                    |  |                                      |              |  |
| Setup   |      |      |                                 |  |  |  |                                    |  |                                      |              |  |
| Other   |      |      |                                 |  |  |  |                                    |  |                                      |              |  |
| Process   |      |      |                                 |  |  |  |                                    |  |                                      |              |  |
| Supplier  |      |      |                                 |  |  |  |                                    |  |                                      |              |  |
| Training  |      |      |                                 |  |  |  |                                    |  |                                      |              |  |
| Unapproved  |      |      |                                 |  |  |  |                                    |  |                                      |              |  |
| FAULT CATEGORY  |      |      |                                 |  |  |  |                                    |  |                                      |              |  |
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube |      |      |                                 | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio<br><input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions |  |  |                                    |  |                                      |              |  |
|   |      |      |                                 | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other  |  |  |                                    |  |                                      |              |  |

|  |  |              |             |
|--|--|--------------|-------------|
| DART AEROSPACE LTD                       |  | Work Order:  | 108753      |
| Description: Litter Deck Plate Kit (350) |  | Part Number: | D2344       |
| Inspection Dwg: D2344 Rev: F             |  |              | Page 1 of 1 |

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

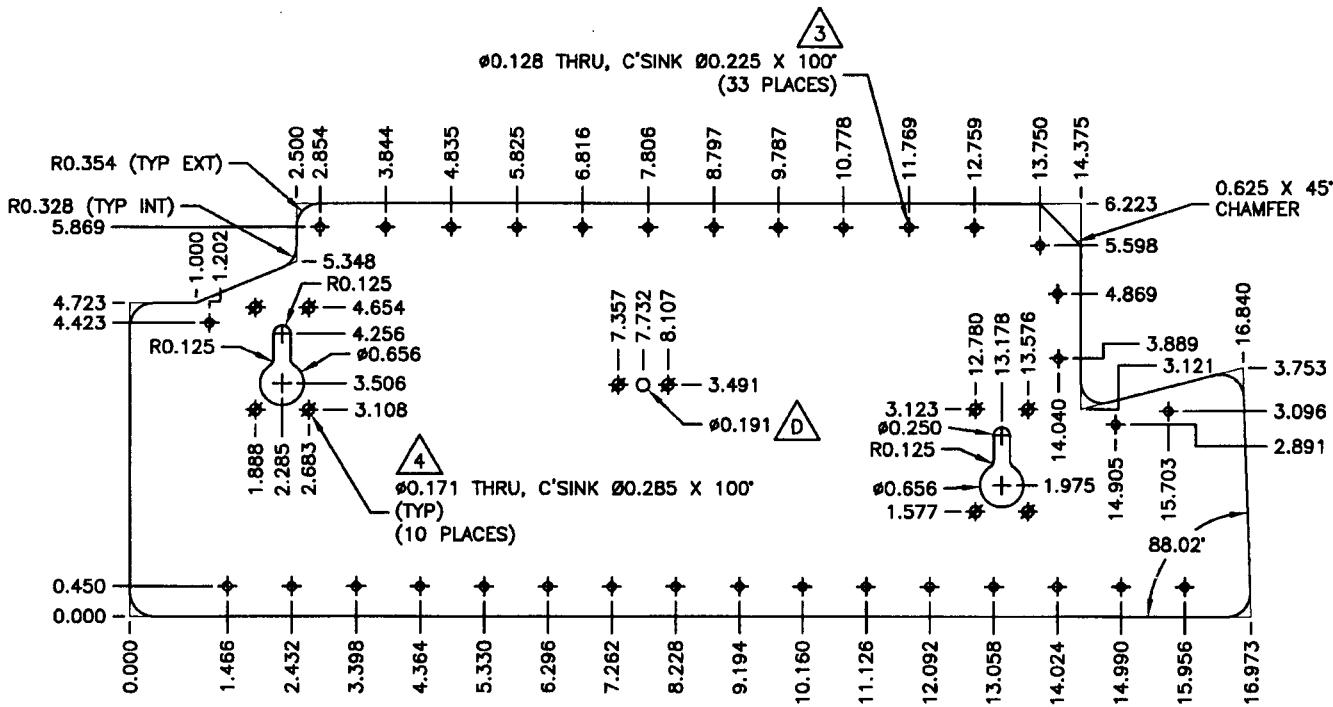
| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 6.223             | +/-0.010      | 6.225"           | -      |        | /                    | Jkm01    |
| 5.598             | +/-0.010      | 5.599"           | -      |        | /                    |          |
| 4.869             | +/-0.010      | 4.873"           | -      |        | /                    |          |
| 3.889             | +/-0.010      | 3.892"           | -      |        | /                    |          |
| 3.096             | +/-0.010      | 3.097"           | -      |        | /                    |          |
| 2.891             | +/-0.010      | 2.896"           | -      |        | /                    |          |
| 16.973            | +/-0.010      | 16.973"          | -      |        | T                    | Jkm06    |
| 0.450             | +/-0.010      | 0.454"           | -      |        | /                    |          |
| 4.423             | +/-0.010      | 4.423"           | -      |        | /                    |          |
| 4.723             | +/-0.010      | 4.725"           | -      |        | /                    |          |
| 1.202             | +/-0.010      | 1.202"           | -      |        | /                    |          |
| 5.869             | +/-0.010      | 5.869"           | -      |        | /                    |          |
| 4.654             | +/-0.010      | 4.655"           | -      |        | /                    |          |
| Ø0.656            | +0.005/-0.000 | 0.656"           | -      |        | /                    |          |
| 1.888             | +/-0.010      | 1.888"           | -      |        | /                    |          |
| 2.285             | +/-0.010      | 2.290"           | -      |        | /                    |          |
| 2.683             | +/-0.010      | 2.685"           | -      |        | /                    |          |
| Ø0.171            | +0.005/-0.000 | 0.171"           | -      |        | /                    |          |
| 3.491             | +/-0.010      | 3.491"           | -      |        | /                    |          |
| Ø0.191            | +0.005/-0.000 | 0.191"           | -      |        | /                    |          |
| 3.123             | +/-0.010      | 3.123"           | -      |        | /                    |          |
| 1.975             | +/-0.010      | 1.980"           | -      |        | /                    |          |
| Ø0.128            | +0.005/-0.001 | 0.129"           | -      | DAS    | /                    |          |

|              |          |             |            |                     |     |
|--------------|----------|-------------|------------|---------------------|-----|
| Measured by: | Jm       | Audited by: | 27<br>9-89 | Prototype Approval: | N/A |
| Date:        | 13-11-15 | Date:       | 13/11/15   | Date:               | N/A |

| Rev | Date     | Change                             | Revised by | Approved |
|-----|----------|------------------------------------|------------|----------|
| A   | 04.06.25 | New Issue P/O D350-616-015         | KJ/JLM     |          |
| B   | 07.07.17 | Dwg Rev. updated                   | KJ/JLM     |          |
| C   | 07.09.06 | Dimensions updated per Dwg. Rev. F | KJ/JLM     | EE       |

**DART**

|                      |                       |   |                        |
|----------------------|-----------------------|---|------------------------|
| DESIGN<br>KE         | DRAWN BY<br><i>SC</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>BS</i> | APPROVED<br><i>TH</i> | DRAWING NO.<br>D2344                              | REV. F<br>SHEET 1 OF 1 |
| DATE<br>07.06.07     |                       | TITLE<br>LITTER DECK PLATE, 350                   | SCALE<br>1:3           |
| A                    | 95.01.14              | NEW ISSUE   |                        |
| B                    | 95.02.09              | MOVED KEY HOLES                                   |                        |
| D                    | 95.03.06              | 0.191 WAS 0.197                                   |                        |
| E                    | 98.06.19              | 0.063-0.071 THICK WAS 0.071<br>(TSR A371)         |                        |
| F                    | 07.06.07              | C'SINK Ø0.285 WAS Ø0.308                          |                        |



D2344 LITTER DECK PLATE, 350

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063-0.071 THICK PER QQ-A-250/4  
(REF. DART SPEC. M2024T3S)
- 2) FINISH: POWDER COAT BLACK SANTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) COUNTERSINK HOLES MARKED  $\diamond$  TO Ø0.225 X 100°
- 4) COUNTERSINK HOLES MARKED  $\diamond$  TO Ø0.285 X 100°
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N "D2344" USING WHITE PAINT MARKER

12-01-01  
DRAFT 801

RELEASED

07.06.07 *TH*

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